

Date: Tuesday, 11/29/2005 3:04:23 PM
 User: Linda Lacelle

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 25017 A
 Estimate Number : 10531
 P.O. Number : N/A Part Number : D2572
 This Issue : 11/29/2005 S.O. No. : N/A Drawing Number : D2572 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
 Previous Run : 24838 Material : N/A
 Due Date : 1/5/2006 Qty: 14 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE DATE & USER
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: ~~25017~~

B 25204 (9)
 B 23940 (5)
 J.G. 06/01/29 14

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 25017 Double check by: SDA/

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

J.G. 06/01/29 14

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

J.G. 06/01/29 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 3:04:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25017

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G. 06/02/22 14

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 06.02.23 14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

~~Q.M.~~ a.m. 06-03-01

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-03-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C 206/03/07 14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

C 206/03/07 (14)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/03/08

Job Completion



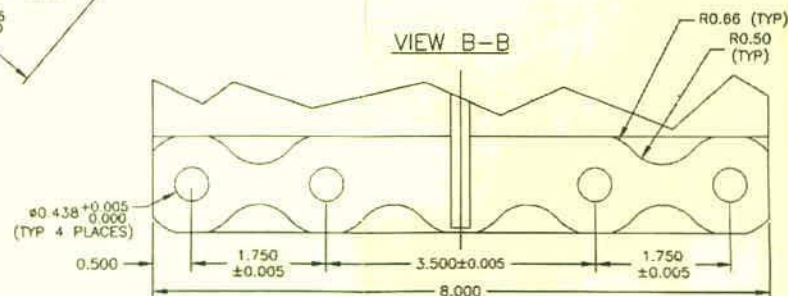
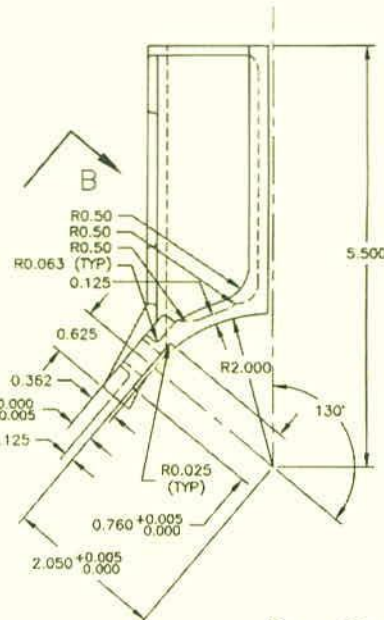
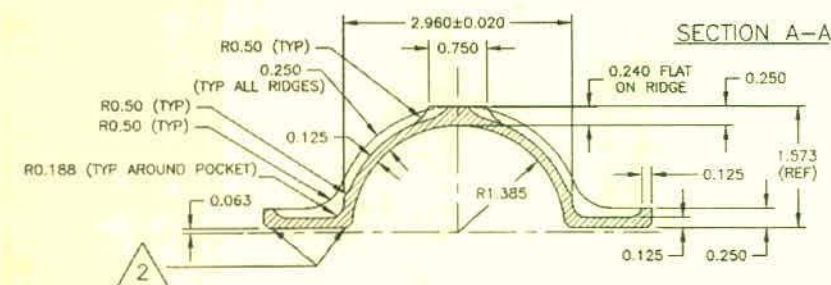
U 06.03.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/03/08
 QA: N/C Closed: _____ Date: _____







NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND

D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN  DRAWN BY   DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA			
CHECKED 	APPROVED 	DRAWING NO. D2572	REV.
DATE 02.09.06		TITLE INNER FWD SADDLE	SHEET 1 OF SCALE

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DART AEROSPACE LTD.

DART

DART AEROSPACE LTD.
HAMMERTOWN, ONTARIO, CANADA

DRAWING NO.	
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TITLE

INNER FWD SADDLE

REV. 0

SHEET 1 OF 1

SCALE

22

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Fwd Inboard		Part Number: D2572	
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.747	1.746	1.745		
C	3.495	3.505		3.496	3.499	3.497	3.495		
D	1.745	1.755		1.746	1.747	1.746	1.745		
E	7.990	8.010		8.005	8.003	8.002	8.003		
F	0.490	0.510		0.496	0.495	0.496	0.499		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.498	0.501	0.499		
J	1.174	1.184		1.177	1.177	1.178	1.177		
K	0.558	0.578		0.572	0.565	0.569	0.567		
L	1.174	1.184		1.178	1.177	1.178	1.177		
M	1.490	1.500		1.495	1.494	1.493	1.495		
N	2.495	2.505		2.497	2.496	2.496	2.498		
O	3.869	3.879		3.872	3.875	3.871	3.872		
P	0.115	0.135		0.126	0.124	0.123	0.123		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.253	0.251	0.251		
S	0.115	0.135		0.130	0.132	0.130	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.959	2.960	2.960	2.960		
V	0.230	0.250		0.246	0.241	0.234	0.234		
W	0.115	0.135		0.131	0.125	0.125	0.123		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.370	0.360	0.360	0.358		
AA	0.470	0.530		0.520	0.520	0.520	0.520		
AB	0.615	0.635		0.615	0.627	0.627	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.254	0.251	0.248	0.246		
AE	1.375	1.395		1.377	1.379	1.383	1.389		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.240	0.240	0.240	0.240		
AH	0.240	0.260		0.257	0.253	0.246	0.246		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP
Date:	06/02/19

Audited by:	J.L
Date:	06-02-20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
11/05/2019

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.746	1.745		
C	3.495	3.505		3.497	3.495	3.497	3.497		
D	1.745	1.755		1.746	1.746	1.746	1.745		
E	7.990	8.010		8.002	8.004	8.004	8.002		
F	0.490	0.510		0.495	0.496	0.506	0.495		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.499	0.499	0.498		
J	1.174	1.184		1.178	1.178	1.177	1.179		
K	0.558	0.578		0.567	0.564	0.568	0.569		
L	1.174	1.184		1.178	1.178	1.177	1.179		
M	1.490	1.500		1.492	1.494	1.493	1.494		
N	2.495	2.505		2.499	2.497	2.496	2.497		
O	3.869	3.879		3.873	3.871	3.870	3.870		
P	0.115	0.135		0.126	0.124	0.123	0.128		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.251	0.250	0.253	0.254		
S	0.115	0.135		0.127	0.127	0.126	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.234	0.233	0.232	0.233		
W	0.115	0.135		0.127	0.127	0.123	0.124		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.625	0.623	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.250	0.245		
AE	1.375	1.395		1.389	1.387	1.386	1.390		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.247	0.243	0.247		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: <u>Er</u>
Date: <u>06/02/20</u>

Audited by: <u>JL</u>
Date: <u>06.02.20</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
11/05/20

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.747	1.748	1.749		
C	3.495	3.505		3.497	3.498	3.497	3.497		
D	1.745	1.755		1.746	1.747	1.747	1.748		
E	7.990	8.010		8.004	8.003	8.002	8.004		
F	0.490	0.510		0.506	0.505	0.506	0.505		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.499	0.499	0.501		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.568	0.568	0.567		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.492		
N	2.495	2.505		2.496	2.497	2.497	2.498		
O	3.869	3.879		3.870	3.870	3.870	3.871		
P	0.115	0.135		0.124	0.130	0.124	0.125		
Q	0.115	0.135		0.130	0.130	0.130	0.136		
R	0.240	0.260		0.251	0.252	0.252	0.253		
S	0.115	0.135		0.126	0.127	0.127	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.961	2.961		
V	0.230	0.250		0.232	0.233	0.233	0.234		
W	0.115	0.135		0.126	0.127	0.127	0.128		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.761	0.761	0.761		
Z	0.352	0.372		0.360	0.361	0.360	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.251	0.251		
AE	1.375	1.395		1.388	1.388	1.389	1.388		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.243	0.243	0.244	0.244		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043							
Accept/Reject									

Measured by: <i>EP/3.6-</i>	Audited by:
Date: <i>06/02/22</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
1/15/22

DART AEROSPACE LTD	Work Order: 25017A
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

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B	1.745	1.755		1.749	1.750				
C	3.495	3.505		3.499	3.499				
D	1.745	1.755		1.749	1.749				
E	7.990	8.010		8.003	8.002				
F	0.490	0.510		0.500	0.501				
G	0.257	0.262	DT8683	0.257	0.257				
H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.499	0.498				
J	1.174	1.184		1.177	1.177				
K	0.558	0.578		0.568	0.568				
L	1.174	1.184		1.179	1.180				
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N	2.495	2.505		2.500	2.499				
O	3.869	3.879		3.870	3.873				
P	0.115	0.135		0.125	0.127				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.244	0.247				
S	0.115	0.135		0.125	0.130				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.240	0.240				
W	0.115	0.135		0.127	0.125				
X	0.307	0.312		0.310	0.316				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.362	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.628	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.244	0.240				
AE	1.375	1.395		1.385	1.387				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.249	0.249				
AI	2.000	2.020		N/A	N/A				
AJ	0.023	0.043		0.030	0.038				
Accept/Reject									

Measured by: J.G.	Audited by:
Date: 06/02/22	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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